Work Order I September-27-13 1:1				*10	768	7*							Page 1	
tem ID: D219 Revision ID: tem Name: Struts				Accept	*N	900	040	100)* s	Setup	Start Stop	171.	S1* S2*	
Start Date: 9/27/	13 Start Qty	y: 2.00	*2*		Cı	ıst Item I	D:							
Required Date: 9/27/	/13 Req'd Qt	ty: 2.00	*2*		Cı	istomer:								
Reference:								_	T	Run	Start			
Approvals: Pro	cess Plan:M_	⊃ Da	te: <u>13-05-2</u>	⊋ Tooling:		Da	ate:		Г	X uii		*N	R1*	
QC		Da	te:	_ SPC (Y/N):		Da	ate:				Stop	*NI	R2*	
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	7	Cool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr											-	\mathcal{S}	
D2199	Rev E1													10
00				0.00					_				1)(10	100
100	NC BRAKE			0.00					2					
Brake NC		Memo	2100 10 0	0.00							į			
Brake NC		Punch per Dwg. D2	2199 and Spec Con	uoi Dwg D2038				•						
10				0.00									//	/ -
110	Small Fab								2x				13/10/2	4 3
Small Fab		Memo		0.00					<u> </u>				11/	9
Small Fab		Deburr												
				2	4S 1 7 89									
120	QC5- Inspec	ct part completeness	s to step on W/O	0.00		•			\sim					
120				13 10	2 24				9					
QC		Memo		0.00	~ <i>I</i>									

Quality Control

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

									QA Closed:	Date	<u> </u>
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
		_			Rework		Skid-tube	Crosstube		Water Jet 🗌	Engineering
Part N	0				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	o				Work Order Update]	Large Fab	Composite		Supplier	
Root		<u> </u>		Descri	ption of work order update	Initial	Ar	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng		ription	Date	Verification	QC Inspector
Doc/Data	1						3000	: IF -: -: 1			30
Equip/Tooling											
Operator		l									
Material	7										
Setup											
Other											
Process											,
Supplier											
Training											
Unapproved											
					F	AULT CATE	GORY				
Landin	g Gear				General		·				
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instruct	tions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Trea	it		_	Countersink	Mislabe	eled		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d ·		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	Offset					
	Torque W			ր	Drawing	Out of	Calibration				
	Turning S	equence			Finish	Out of Sequence					
. [Wave/Tw	ist in Tuk	ne	.	Folio	Outside Dimensions					

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Work Orde September-27-13		·		*10	7687*				Page 2
Revision ID:	D2199-1 Struts, 19"			Accept	*N900040	100*	Setup	Start 7	*NS1* *NS2*
Start Date: Required Date: Reference:	9/27/13 9/27/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:				
Approvals:	Process Pla	an:	_	Tooling: SPC (Y/N):	Date:			Stop	*NR1* *NR2*
Sequence ID/ Work Center II 130 *130* Powdercoat Powder Coating)	Operation Description White Gloss(Ref: 4.3.5.2 M/D6/D5 Memo START TIL	0.0	Set Up/ Run Hours 0.00 0.00 OVEN TEMPERATU	Tool ID Tool #	Plan Acce Code Qty	pt Reje Qty	Nui	ect Insp. mber Stamp DA 34 9-8
140 *140 QC Quality Control		QC3- Inspect Part Finisl Memo		0.00 DAS 27 989 0.00 Blo	3 5	2			
150 *150* Packaging		Identify as per dwg & Si	rock Location: 5726	0.00		2	DAS × 28	13.	-10-25_

9-89

Packaging

NCR: Y	es/	/ No				WORK ORDER NON-O		NFORM	MANCE / UPC	DATE			
										***	QA Closed:	Date	j:
Work Orde	er: .					DISPOSITION				_	EPARTMENT,	_	
Part N	•					Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Crosstube Small Fab Finishing Composite	- i	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update	I	nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
Landi					·	General F	AUL	T CATE	JURY	· · · · · · · · · · · · · · · · · · ·			
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in	Crimped. It n Strip in I Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete tions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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Work Orde				*107	7687*							Page 3	
Item ID: Revision ID: Item Name:	D2199-1 Struts, 19		<u> </u>	Accept	*N900	040	100)*	Setup	Start Stop	*N: *N:	S1* S2*	**************************************
Start Date: Required Date: Reference:	9/27/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:							
Approvals:	Process	s Plan:	Date:	Tooling:	Da	ate:			Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	Da	nte:				Stop	*N	R2*	
Sequence ID/ Work Center I	D.	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re	•	Reject Number	Insp. Stamp	
160		QC21- Final Inspection	- Work Order Release	0.00				مالك	1 pm	12/	m loo		
160 QC Quality Control		Memo		0.00			(1)//	* #	13/1			

1810-25

												DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE		•			
		•							•			QA Closed:	Da	ate:	
Work Orde	ar:					DISPOSITION				AGAINST D	ÞΕΙ	PARTMENT	PROCESS		
Work Ordi	- -					Rework	1		Skid-tube	Crosstube	_		Water Jet		Engineering
Part I	No					Scrap	1		Machining	Small Fab	\dashv	Pro	d. Eng. Coor.	\vdash	Quality
raiti	1 0				<u> </u>	Use-as-is	1	t .	noforming	Finishing	┪		e/Packaging	-	Other
NCR I	Vo.					Work Order Update	1		Large Fab	Composite		1100,5001	Supplier	-	J
	_						_							ш	
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	n n	QC Inspector
Doc/Data		·													
Equip/Tooling	Ш														
Operator							1	,							
Material															
Setup	Ш													ļ	
Other															
Process	Ш		·												
Supplier	Ш														
Training	Ш														
Unapproved															
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Landi					_	General	_	,		-		1		_	1
	Ш	Bending				Bend		Grain				Ovalized			Pressure/Forced
	\vdash	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa		1		Over/Under			Temperature/Cure
	Ь——	Cracks				Broken/Damaged		4	on Incomplete			Part Incorre		L	Weld
	Ц̈́	Crushed/0	Crimped.			Burrs		-1	ions Incomplete	'Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
1		Cuffs				Contamination		Mainte	nance	İ		Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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September-27-13 1:10:01 PM

Work Order ID:

107687

Parent Item:

D2199-1

Parent Item Name:

Struts, 19"

Start Date: 9/27/13

Required Date: 9/27/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP B02.06.10Added finish NG/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049V	v	Purchased	No			100	f	491.8229	1.55	3.2631578		So	13/0/10

Location	Loc Qty	Loc Code	
MAT017	491.8228505		
122312	13.3		
122468	0.0000325	•	
124768	55.31245		
125068	4.5664		
M126183	299.120001		4.5
M126349	119.523967		•

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	,								QA Closed:	Date	:
Work Order	•				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No					Rework Scrap Use-as-is	1 1	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No	o			·	Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
оларриотеа		!	<u> </u>		F/	AULT CATE	GORY		I		
Landing	g Gear				General						
	Bending Centre No Cracks Crushed/			o/s	Bend BOM/Route Broken/Damaged Burrs		are ion Incomplete tions Incomplete/U	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
-	Cuffs Heat Trea	·			Contamination Countersink	⊢	enance		Part Moved Positioned V	_	
-	Inspection Ripples in	n Strip in	Tube		Cut Too Short Drill Holes	Misrea			Power Loss/		Other
	Torque W	aves in E	xtrusion	, <u> </u>	Drawing	Out of	Calibration				
-	Turning S Wave/Tw		e e		Finish Folio		Sequence e Dimensions				

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# 4 Service		

DART AEROSPACE LTD



Description:		Work Order: イクテ くる子
Inspection Drawing: 7 2565	Rev: E/	Part Number: D 2 99-1

INSPECTION SHEET

rawin	g Dimensio	n Tolerance	Actual Dimension	Accept	Reject	Method of Inspectio	on Comments
		# .030	12 - 30			1	SB-5
17.	30	+1030	17.50			1	\$0-5
Ø	257	1/2.005	0.257	/			SD - S SD - (1
			7				
						-, , , , , , , , , , , , , , , , , , ,	
	1.10						
					·		
						DAS	
leasin	red by:		Checked By:	DAS	QC insp	ectors	Engineering Approval (if necessar)